

Monday, 2/5/2007 8:06:57 AM
Kim Johnston

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 30592	
Estimate Number : 10530	
P.O. Number : N/A	Part Number : D2571
This Issue : 2/5/2007 S.O. No. : N/A	Drawing Number : D2571 REV E
First Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : E
Previous Run : 30212	Material : N/A
Written By : <u>JA 07.02.05</u>	Due Date : 2/15/2007
Checked & Approved By : <u>JA 07.02.05</u>	Qty: 12 Um: Each
Comment : Est: 1 02:40.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ	

Additional Product

Job Number:



Seq. #

Machine Or Operation:

Description :

1.0

D6101-007

7075-T7351 8.25X7.75X2.5



Comment: Qty. 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: 25355 25354 (3)

MS 07/04/20

BC 07/04/23

(3)

(4)

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 336542 Double check by: JF-J.L

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

MS 07/04/20 / Cr 07/04/23 (3)
JF / BC 07/04/23 / Cr (4)

3.0

MILLING CONV

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

MS 07/04/20 / Cr 07/04/23 (3)
JF / BC 07/04/23 / Cr (4)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 07/04/20 / Cr 07/04/23 (3)
JF / BC 07/04/23 / Cr (4)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 30592

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description:

50

QC3

SECOND CHECK



Comment: SECOND CHECK

SA 07.04.23

60

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL

07/04/23-

70

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

NI 103706

HL

07-04-23

(3)

80

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/04/24 (3)

90

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/04/24 (3)

100

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/24

(3)

Completion:



DART AEROSPACE LTD	Work Order:	305912
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.748	1.749	1.748		
C	3.495	3.505		3.500	3.499	3.501	3.499		
D	1.745	1.755		1.750	1.748	1.749	1.748		
E	7.990	8.010		8.001	7.998	7.999	8.002		
F	0.490	0.510		0.507	0.499	0.496	0.497		
G	0.257	0.262	DT8683	0.259	0.258	0.258	0.260		
H	0.375	0.380	DT8684	0.376	0.378	0.378	0.378		
I	0.490	0.510		0.500	0.502	0.501	0.503		
J	1.174	1.184		1.178	1.176	1.177	1.174		
K	0.558	0.578		0.568	0.564	0.568	0.568		
L	1.174	1.184		1.178	1.176	1.177	1.174		
M	1.490	1.500		1.495	1.494	1.493	1.493		
N	2.495	2.505		2.500	2.497	2.496	2.497		
O	3.869	3.879		3.871	3.871	3.871	3.872		
P	0.115	0.135		0.127	0.134	0.128	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.243	0.249	0.254	0.253		
S	0.115	0.135		0.135	0.130	0.134	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.963	2.960	2.960	2.960		
V	0.230	0.250		0.242	0.230	0.241	0.238		
W	0.115	0.135		0.122	0.125	0.126	0.121		
X	0.308	0.313		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.359	0.364	0.369	0.369		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.634	0.626	0.629	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.246	0.254	0.253		
AE	1.375	1.395		1.383	1.386	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	0.249	0.258	0.253		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	GIN/MS/En	Audited by:	SN
Date:	02/10/14	Date:	02/04/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

